

STL TODAY 10/08/09

Work Order ID 61027

August 4, 2010 10:18:52 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4079-1

Revision ID: PRELIM

Item Name: Clamp Half, Attachment

Start Date: 04/08/2010 Start Qty: 2.00

Required Date: 10/08/2010 Req'd Qty: 2.00

Reference: *10.08.04*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4079	<i>PA1 Rev B</i>

100



Bandsaw

Memo

0.00

88 10/08/08

2 0

110



HAAS 1

HAAS CNC vertical machine #1

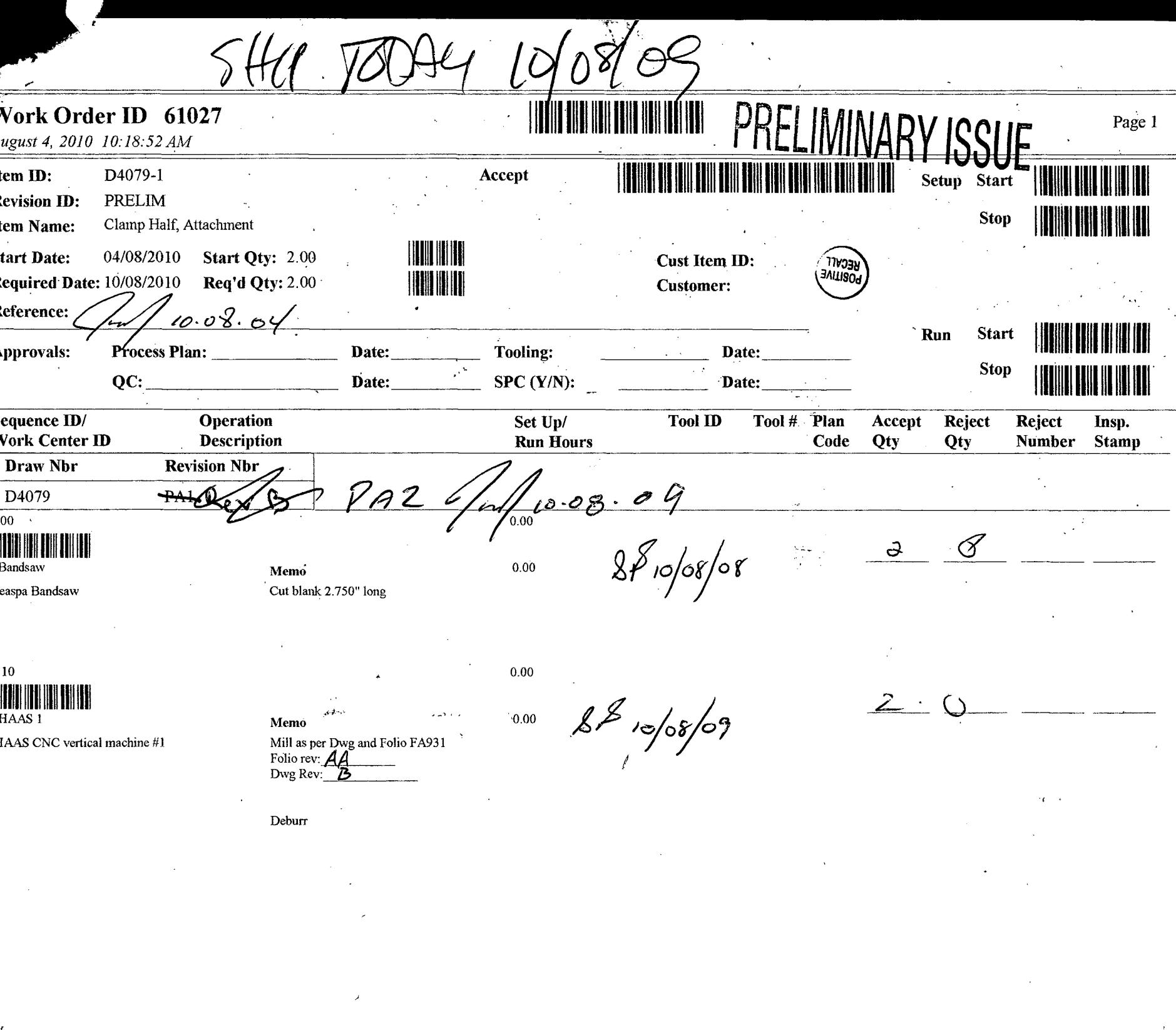
Memo

0.00

88 10/08/08

2 0

Deburr



Work Order ID 61027

August 4, 2010 10:18:52 AM



Page 2

Item ID: D4079-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Clamp Half, Attachment

Stop



Start Date: 04/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/08/2010 Req'd Qty: 2.00



Customer:

Reference: *10.08.04.*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*88, 10/08/09**2 0*

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*- inspected & Prod Day**_____*

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

*only
S10000**ml 10 08 09 (2)*

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Page 3

Item ID: D4079-1

Accept



Setup

Start



Revision ID: PRELIM

Stop



Item Name: Clamp Half, Attachment

Start Date: 04/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/08/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3



Powdercoat

Powder Coating

Set Up/
Run Hours

0.00

JL

Tool ID

10/08/09

Tool #

Plan
CodeAccept
Qty

X2

Reject
Qty

0

Reject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

10/8/9 SP (2)

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

10/8/9 SP 50

Work Order ID 61027

Page 4

August 4, 2010 10:18:52 AM

Item ID: D4079-1

Accept



Setup Start

**Revision ID:** PRELIM

Stop

**Item Name:** Clamp Half, Attachment**Start Date:** 04/08/2010 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 10/08/2010 **Req'd Qty:** 2.00**Customer:****Reference:****Approvals:****Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**

180



QC21- Final Inspection - Work Order Release

QC

Quality Control

**Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

0.00

Memo**POSITIVE RECALL****EFFECTIVE 10-8-04 AUTH LL****RELEASED _____ DATE _____**

MF
10-8-9

PD 1324

Picklist Print

Page 1

August 4, 2010 10:18:52 AM

Work Order ID: 61027



Parent Item: D4079-1



Parent Item Name: Clamp Half, Attachment

Start Date: 04/08/2010

Required Date: 10/08/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased		No		100	f	41.9978	0.23	0.484211			

6061-T6 Bar 2.00 x 2.00



Location	Loc Qty	Loc Code
MAT09	41.9978	
113006	20	
113123	12.9978	
13085	9	

.4843

8/10/08

DART AEROSPACE LTD	Work Order:	61027
Description: clamp half attachment	Part Number:	04079
Inspection Dwg: D4079 Rev: 5 PA2		Page 1 of 1

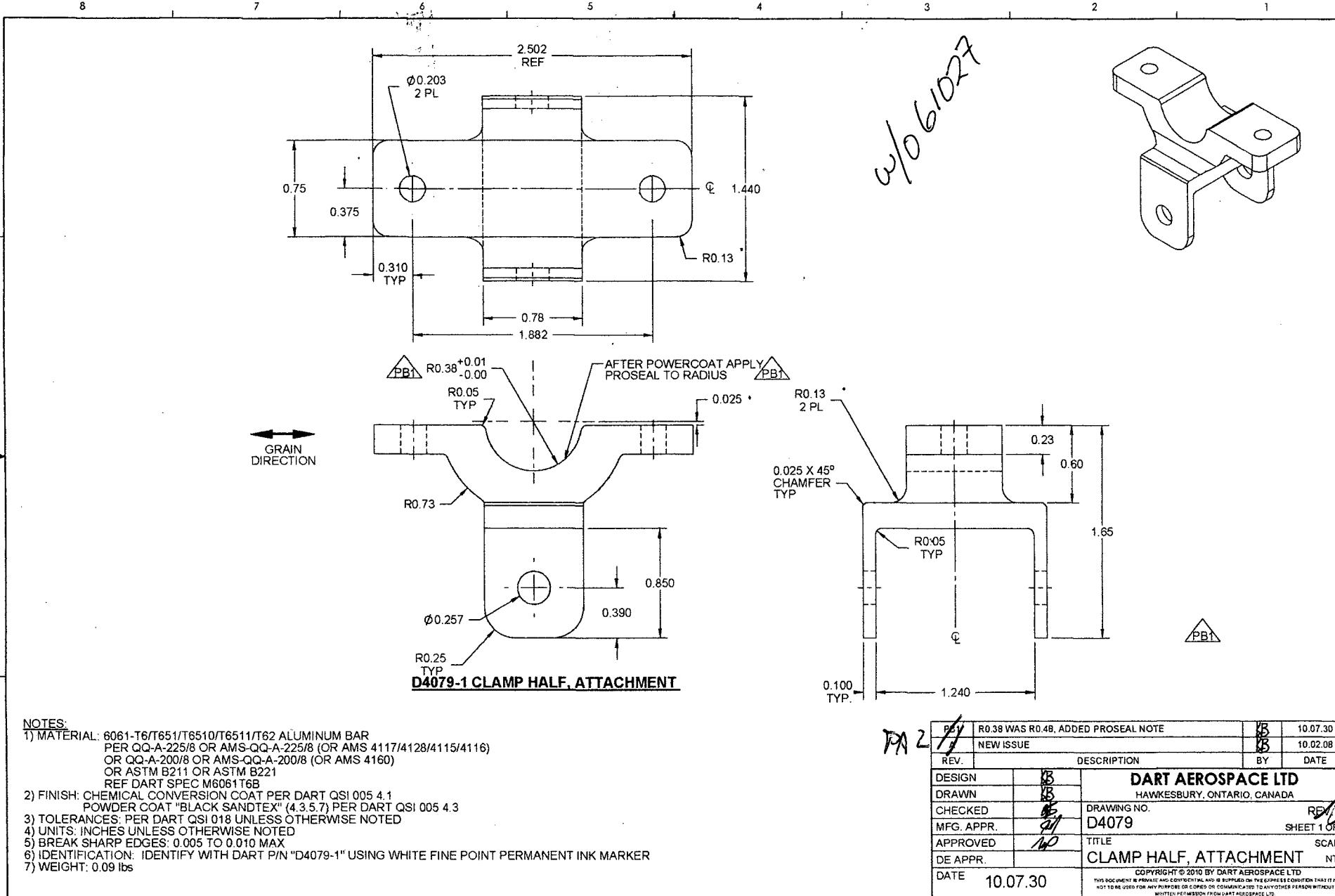
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.75	$\pm .030$.748	✓		✓ SF12	
.78	"	.784	✓		"	
.23	"	.227	✓		"	
.60	"	.595	✓			
1.65	"	1.650	-		High gauge	
2.502	$\pm .010$	2.504	✓		✓ SF12	
1.440	"	1.445	-		"	
1.882	"	1.879	✓	-	"	
.310	"	.310	-		"	
.375	"	.375	-		"	
.025	"	.025	✓		High gauge	
.850	"	.845	✓		✓ SF12	
.390	"	.390	✓		"	
1.240	"	1.241	✓		"	
.100	"	.098	✓		"	
R.050		.062	-		Rad gauge	
R.130		.125	-		"	
R.730		<u> </u>	-	-	✓	
R.025		.250	✓		Rad gauge	
0.38	$\pm .010$ $\pm .005$.385	✓		High gauge	
Ø.203	$\pm .005$ $\pm .001$.203	-		✓ SF12	
Ø.257	$\pm .006$ $\pm .001$.257			"	

Measured by:	<i>SP</i>	Audited by:	<i>S</i>	Preliminary Approval:	
Date:	10/08/09	Date:	10/08/09	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

SP 10.04.15



PA 2

REV.	R0.38 WAS R0.48, ADDED PROSEAL NOTE NEW ISSUE	10.07.30
DESIGN	10.07.30	10.02.08
DRAWN	10.07.30	10.02.08
CHECKED	10.07.30	10.02.08
MFG. APPR.	10.07.30	10.02.08
APPROVED	10.07.30	10.02.08
DE APPR.	10.07.30	10.02.08
DATE	10.07.30	10.02.08

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4079 SHEET 1 OF 1
TITLE CLAMP HALF, ATTACHMENT NTS

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PA 2

8 7 6 5 4 3 2 1

Kim Johnston

From: David Shepherd [dshepherd@dartaero.com]
Sent: Wednesday, August 11, 2010 6:46 PM
To: 'Kim Johnston'
Subject: RE: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Yes ... They will be scrapped afterwards or used for Show purposes.

David

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Tuesday, August 10, 2010 9:02 AM
To: David Shepherd
Subject: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Hi David,

I have two prelim work orders, D4079-1 B61027 and D4078-1 B61029. Mike tells me that they were sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after. I'll attach your email to the work orders and file them. Thanks,

Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
1270 Aberdeen Street
Hawkesbury, Ontario, K6A 1K7
Email: kjohnston@dartaero.com
Tel: 613-632-5200
Fax: 613-632-9311

No virus found in this incoming message.
Checked by AVG - www.avg.com
Version: 8.5.441 / Virus Database: 271.1.1/3061 - Release Date: 08/09/10 18:35:00